

Work Order ID 66670



Page 1

Wednesday, February 23, 2011 2:19:19 PM

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 2/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: 11-02-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev.D DEO-D1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG003

Handwritten: 8/11/03/04

Handwritten: CK Per BG 11/03/04

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

Handwritten: DP

Handwritten: 11-02-23

Handwritten: 366670

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends and remove bending marks

2- Prepare tube for swaging as per QSI 002

130

0.00



QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

11-2-23

1 8 BE 11/02/28

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod

m116577

BE 11/02/08

2-Grind welds on step as per Dwg D2580

BE 11/02/08

3-Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002
and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start
expansion and finish with 1/2 x 18G to achieve dwg dimension.

BE 11/02/08

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Debur

BE 11/03/02

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

BE 11/03/02

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

BE 11/03/02

P.T.O. →

150

QC10- Inspect visual per QSI004- ground welds 0.00



QC

Memo

0.00

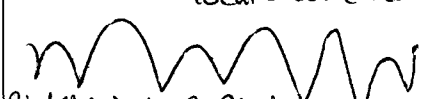
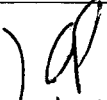

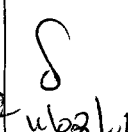
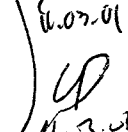
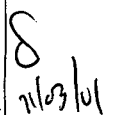
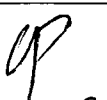
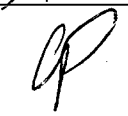
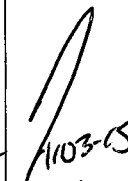
Sul103/02

(FV)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D205-634-041 PAR #: _____ Fault Category: Skullies NCR: Yes No DQA: _____ Date: 11/03/15
 Resolution: rework Disposition: rework QA: N/C Closed: _____ Date: 11/03/15

NCR: 66670		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/03/01	140.6	operator drilled both holes (1 one each side of tube) 2" 41 the Prod End For ATF CAP. P.C. employee didn't pay attention to orientation of drill jig. Jig didn't have a note on how to locate it correctly  R: LCA → improper training		→ Fill in both holes with weld A/R <u>M116577</u>	BE 11/03/02	8 11/03/02		
			11.03.01	→ Grind outside + inside flush	BE 11/03/02			
			11.03.01	→ re-drill holes in correct location	BE 11/03/02			
			11.03.02	→ scribble D78215 scribe note on Jig to position it correctly. / Fill w/ weld	BE 11/03/02	8 11/03/02		
				Fill w/ weld. Not in spec No effect on strength of tube		← →		

NOTE: Date & initial all entries

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Item ID: D205-634-041

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Revision ID:

Item Name: Replacement Skidtube

Start Date: 2/23/2011 Start Qty: 1.00

Required Date: 3/11/2011 Req'd Qty: 1.00

Reference:




Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
		8 11/03/02							
170  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.	0.00 0.00							
180  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M115951 Memo START TIME: OVEN TEMPERATURE: FINISH TIME:	0.00 0.00							
		11:00 320°F 11:30							

①X
M-L 11/03/03①X
M-L 11/03/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D205-634-041

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Start Date: 2/23/2011 Start Qty: 1.00

Required Date: 3/11/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 2 11/03/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

Cust Item ID:

Customer:

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Run Start
Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



HandFinish

0.00

Hand Finishing

Memo

- ✓ 1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 ☐ 111160410
Sikaflex expire date: 11105
- ✓ 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580
- ✓ 3-Inspect for foreign object per QSI 024
- ✓ 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 ☐ 111160410
Sikaflex expire date: 11105
- ✓ 5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: 11116462

1 6 22 4/03/03

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, February 23, 2011 2:19:32 PM

Page 1

Work Order ID: 66670

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube




Start Date: 2/23/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
KJ IPP Rev P 10.02.19
per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1  Spacer		Manufactured	No			140	Each	166.0000	20	20		BE 11/02/28	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				166					
					65529			166		20			
D2580-1  205 Skidtube bent detail		Manufactured	No			110	Each	5.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST046				5					
				59856				1					
				66095				2					
				66268				2					
D2576-3  Step (maching detail)		Manufactured	No			140	Each	52.0000	1	1		11-2-23	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				52					
				46661				4					
				52215				48					

W/O:		WORK ORDER CHANGES					
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Page 2

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Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 2/23/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200

Each

42.0000

1



Cap



11/03/03

Location

Loc Qty

Loc Code

FP6

1

56613

1

ST026

41

50513

1

50770

28

51539

2

53791

10

AN3-5A

Purchased

No

200

Each

732.0000

2



Bolt



11/03/03

Location

Loc Qty

Loc Code

ST350

732

115016

56

115371

500

116632

176

AN960JD10L

NAS1149D0332J

Purchased

No

200

Each

6.0000

2



Washer



11/03/03

Location

Loc Qty

Loc Code

ST335

6

11912

6

M117010

11/03/03

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube

Start Date: 2/23/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

200

Each

1,814.000

50

50



Insert



1103103

Location

Loc Qty

Loc Code

FP

21

115079

21

ST282

1793

111529

32

113238

17

115502

500

115581

244

116800

1000

X50

AN3C4A

Purchased

No

200

Each

2,296.000

50

50



BOLT



1103103

Location

Loc Qty

Loc Code

ST350

2296

115300

25

116075

337

116704

734

116924

1200

X50

AN960C10L

NAS1149C0332

Purchased

No

200

Each

127.0000

50

50



washer



1103103

Location

Loc Qty

Loc Code

ST245

127

107534

59

108246

68

11116304

X50

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Page 3

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Start Date: 2/23/2011




Required Date: 3/11/2011

Start Qty: 1.00




Required Qty: 1.00

D3566-13 Manufactured No 200 Each 34.0000 1 1
Gasket    11/03/07




<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP014	34	
64070	17	
66137	17	

D3566-5 Manufactured No 200 Each 13.0000 1 1
Gasket    11/03/07

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP015	13	
63574	1	
66146	12	

D3566-1 Manufactured No 200 Each 33.0000 2 2
Gasket    11/03/07

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP015	33	
57715	1	
66040	20	
66129	12	

D3564-11 Manufactured No 200 Each 11.0000 1 1
Wearshoe    11/03/07

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP019	11	
65159	11	

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Start Date: 2/23/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-13 Manufactured No 200 Each 25.0000 1 1
Wearshoe
JH 4/03/07

Location	Loc Qty	Loc Code
FP17	25	365522
59660	1	
62229	2	
66136	22	

D3564-9 Manufactured No 200 Each 4.0000 1 1
Wearshoe
JH 4/03/03

Location	Loc Qty	Loc Code
FP	1	
55334	1	
FP19	3	
62238	3	

D3564-5 Manufactured No 200 Each 19.0000 1 1
Wearshoe
JH 4/03/03

Location	Loc Qty	Loc Code
FG	1	
34806	1	
FP19	2	
57525	1	
58709	1	
FP-19	16	365523
63575	1	
66148	15	

W/O:		WORK ORDER CHANGES					
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Start Date: 2/23/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2594-3

Manufactured No

200

Each

1,031.000

16

16



O-Ring, 205 Skidtube



11/03/03

Location

Loc Qty

Loc Code

FP

543

55546

19

58191

12

59358

12

65518

500

fpa

488

61762

488

x16

D2594-1

Manufactured No

200

Each

327.0000

16

16



Plug, 205 Skidtube



11/03/03

Location

Loc Qty

Loc Code

FP

183

42807

112

55002

71

FP14

144

58434

15

65980

129

x16

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 #**DEO ATTACHED**

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46676

[Signature] 11-0223

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

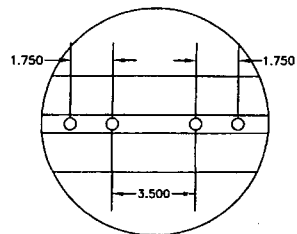
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

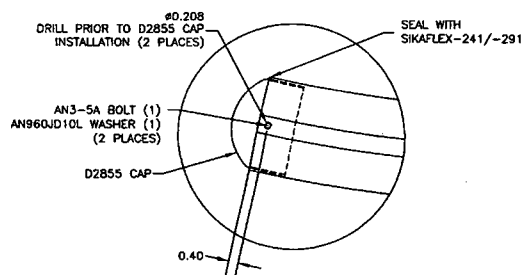
DETAIL A
SCALE 5:24



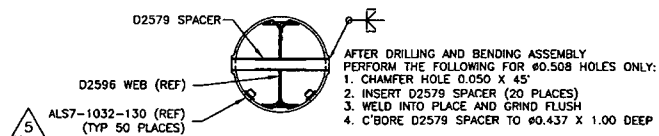
RELEASED
07-06-28

DEO ATTACHED

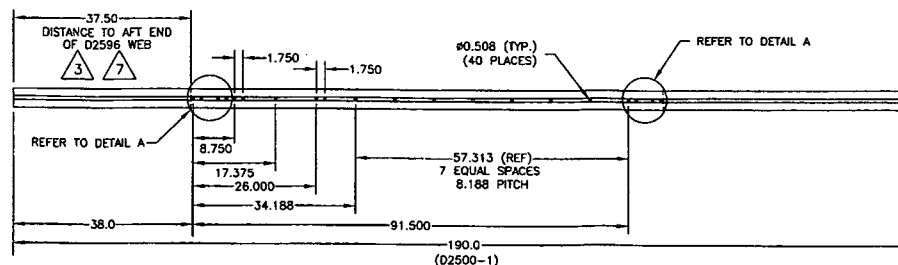
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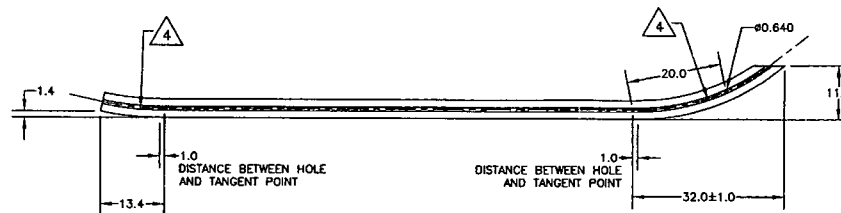
SECTION D-D
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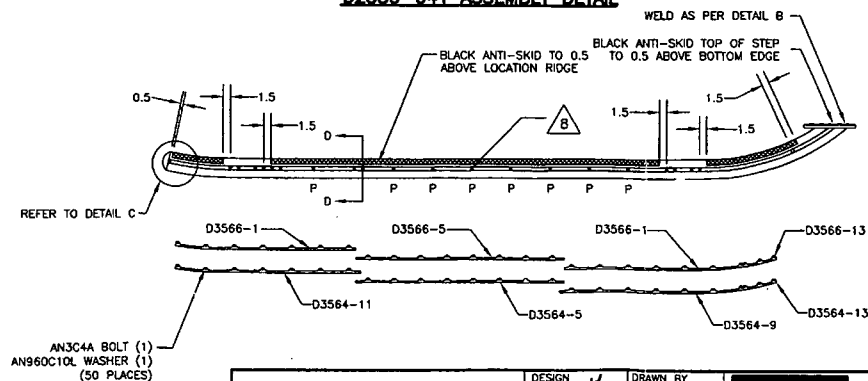
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

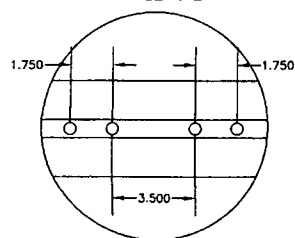
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

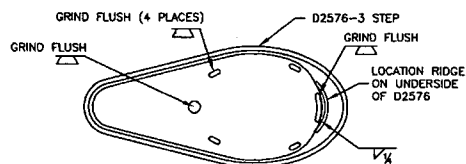
NOTE: Date & initial all entries

DETAIL E
SCALE 5:24



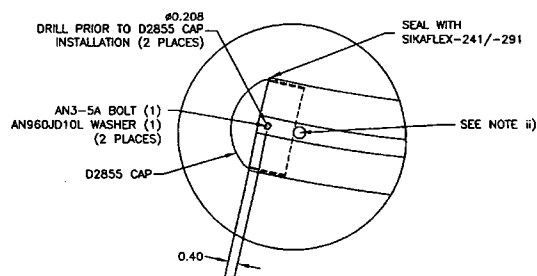
RELEASED
07 Dec 78

DETAIL F
SCALE 5:24

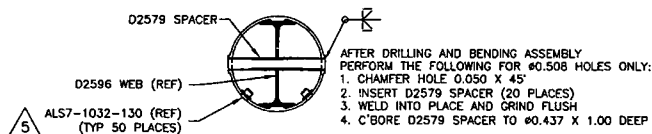


DEO ATTACHED

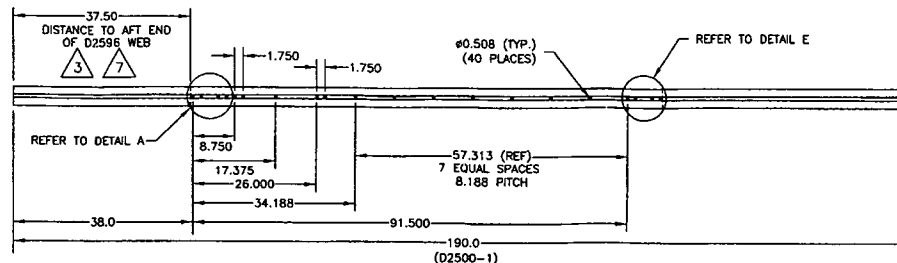
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SCALE 5:24



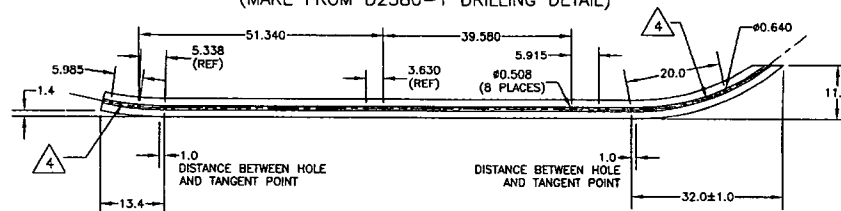
SECTION H-H
SCALE 5:24



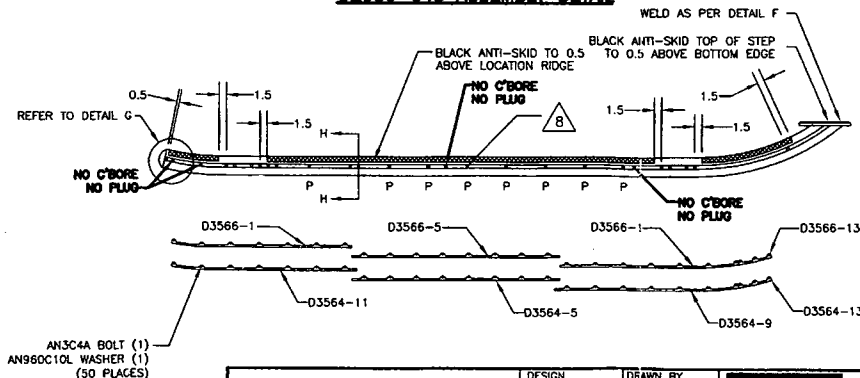
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN R4	DRAWN BY R4	DART	DART AEROSPACE LTD. WARRICKBURGH, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D2580	TITLE 205 SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2580-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>L</i>	MFG. APPR. <i>R</i>	APPROVED <i>MP</i>		DE APPR. <i>H</i>		
DATE 10.09.22	DATE 10.11.04	DATE 10.11.04	DATE 10/11/04		DATE 10.11.04		

PURPOSE:

CHANGE ALL WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

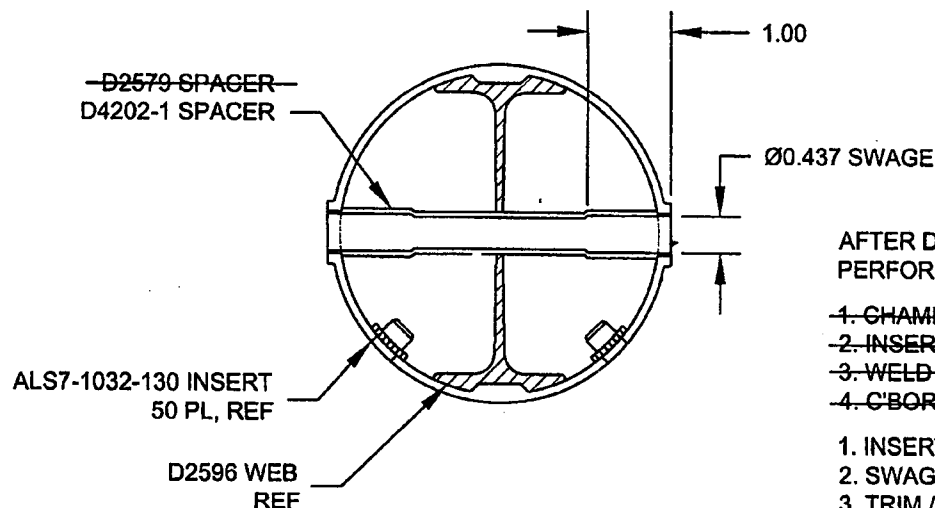
WAS

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-045		
20	24	D2579	CROSS BOLT SPACER

IS

20	24	D4202-1	SPACER
----	----	---------	--------

SECTION D-D & SECTION H-H ARE AMENDED AS FOLLOWS:



SECTION D-D
NOT TO SCALE

SECTION H-H
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

1. INSERT D4202-1 SPACER, 20 PL (-041) OR 24 PL (-045)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

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2010-11-18
MP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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